

Date: Tuesday, 5/23/2006 11:35:57 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TAIL LIGHT FAIRING
Job Number : 27214	
Estimate Number : 12364	
P.O. Number : N/A	Part Number : D3484041
This Issue : 5/23/2006 S.O. No. : N/A	Drawing Number : D3484 PRELIMINARY
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <i>See comment below</i>	Due Date : 5/30/2006 Qty: <i>1</i> Um: <i>06-05-23</i> Each
Checked & Approved By : <i>06-05-23 W</i>	
Comment : Est Rev: A New Issue 06-04-11 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34841	BASE, LH
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 BASE, LH  
 Batch: *B27221*

*06/05/31*

2.0	D34843	FACE, LH
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 FACE, LH  
 Batch: *B27223*

*06/05/31*

3.0	D34845	CONE, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 CONE, LH  
 Batch: *B27225*

*06/05/31*

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig  
 A/R AL ROD Batch: *M18838*

*06/05/31*

2-Buff & Smooth Welds to mating surfaces

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 5/23/2006 11:35:57 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 27214

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5/9

WELD INSPECTION



PD 06-06-05

*2006-06-05 ①*

Comment: WELD INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SAD*

*06-06-05*

①

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*2006-06-05 ①*

8.0

MS20426AD33

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch: *M7681*

9.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

ANCHOR NUT

Batch: *M19633*

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

*SB 06/06/05 ①*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

*306619*

*NTA*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   D   Date: 06/06/19

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 5/23/2006 11:35:57 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 27214

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5060619

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N:D412-750-141 B/N:BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

6/6/19 ①

①

Job Completion



Level 21 inspection.

5060619

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

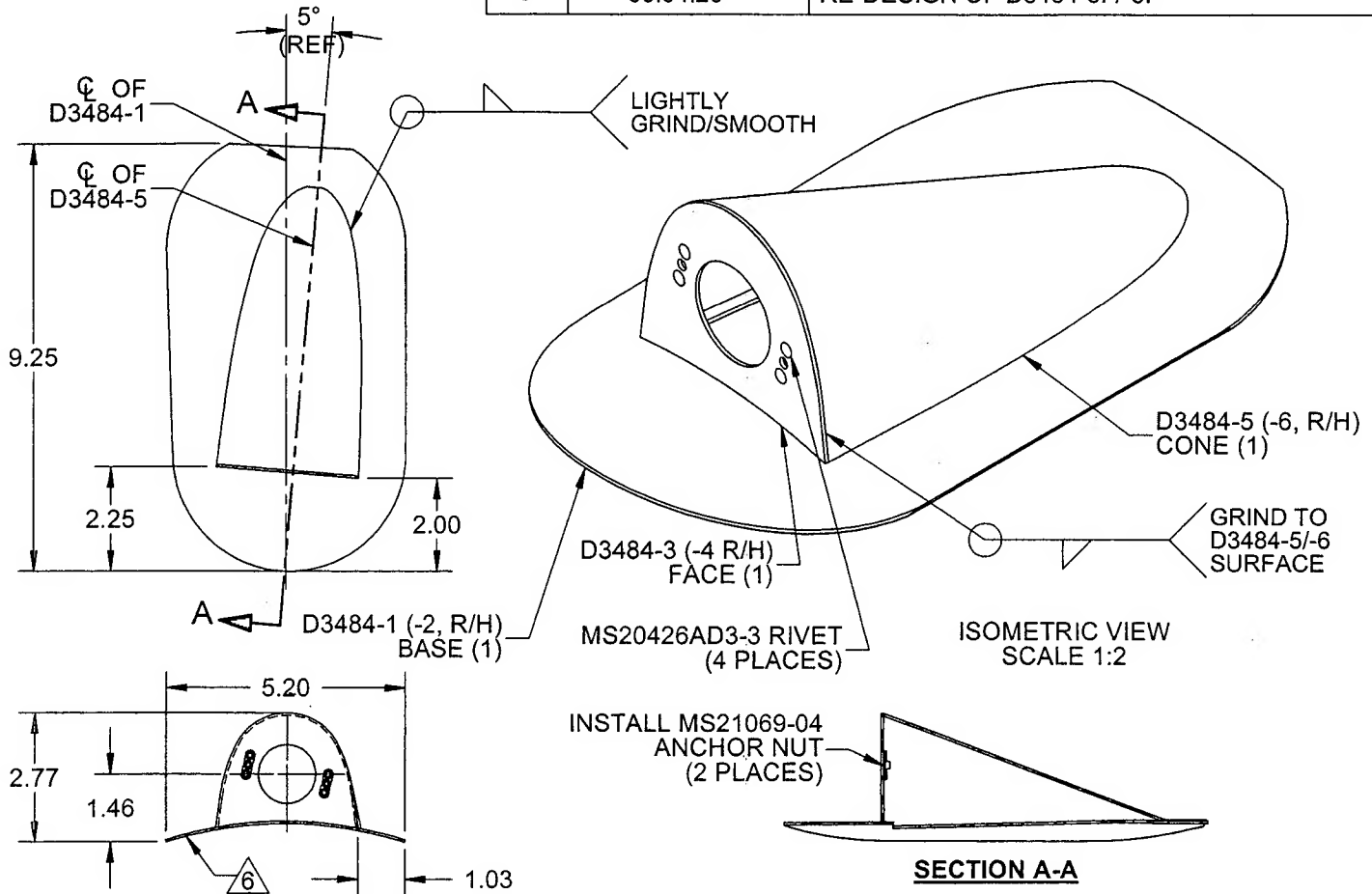
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NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**PRELIMINARY ISSUE**  
 06.03.16

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3484	REV. C SHEET 1 OF 4
DATE 06.04.20		TITLE TAIL LIGHT FAIRING	SCALE 1:4
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	



### D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POSSIBLE TO POWDER COAT PAINT WHITE (4.3.5.1) PER DART QSI 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD.,  
P/N D412-750-141/-142 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE  
PDA06-13"

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H)
1		D3484-3	FACE (L/H)
	1	D3484-4	FACE (R/H)
1		D3484-5	CONE (L/H)
	1	D3484-6	CONE (R/H)
4	4	MS20426AD3-3	RIVET
2	2	MS21069-04	ANCHOR NUT

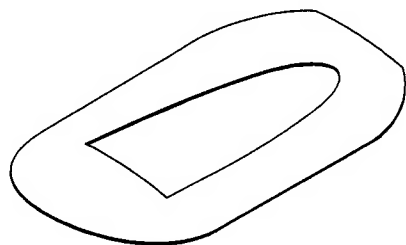
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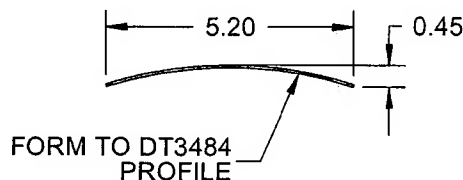
**PRELIMINARY ISSUE**

06.05.16

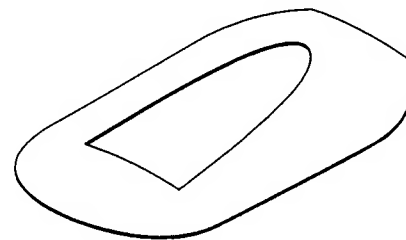
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CHECKED	APPROVED	DRAWING NO. D3484	REV. C SHEET 2 OF 4
DATE 06.04.20		TITLE TAIL LIGHT FAIRING	SCALE 1:2



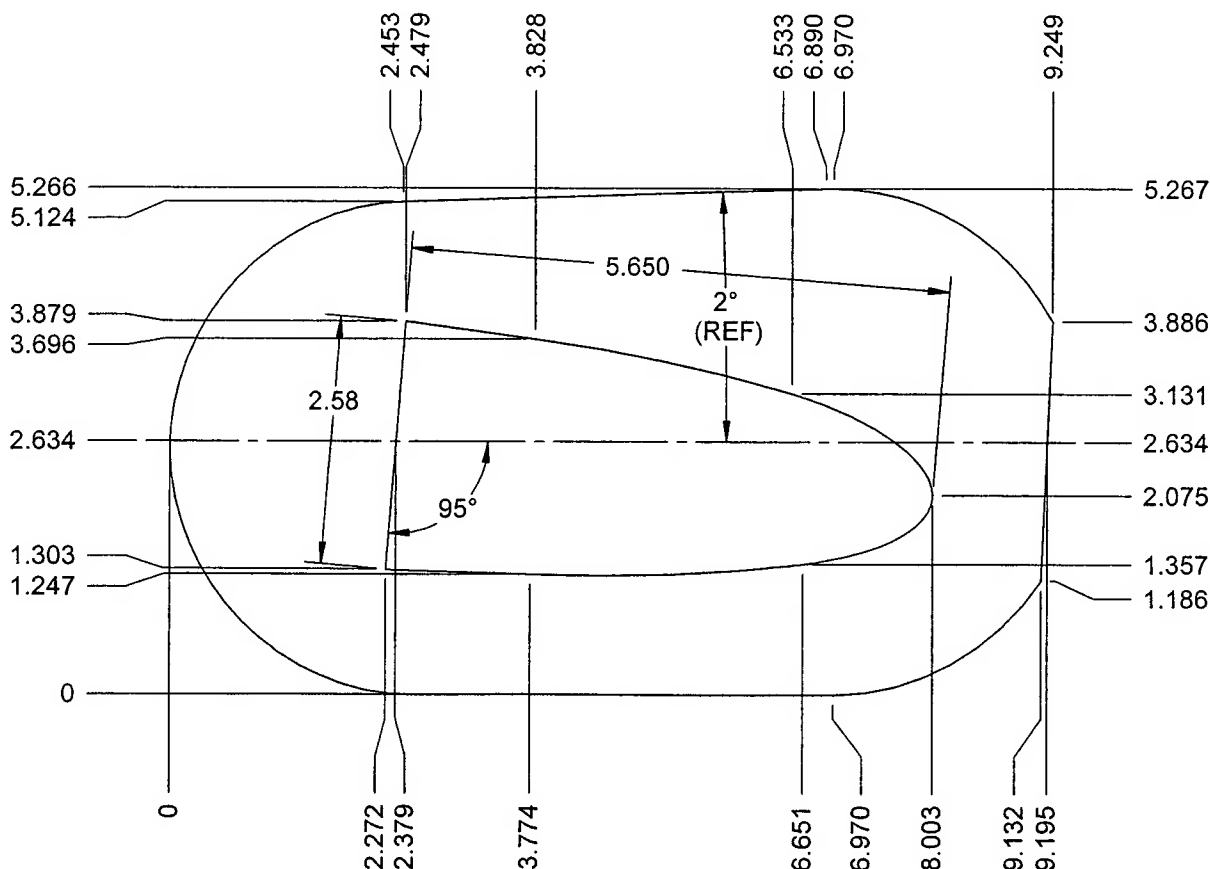
**D3484-1 BASE, L/H**



**D3484-1/-2 BENDING DETAIL**  
(MAKE FROM D3484-1F)



**D3484-2 BASE, R/H**



**D3484-1F BASE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 27214

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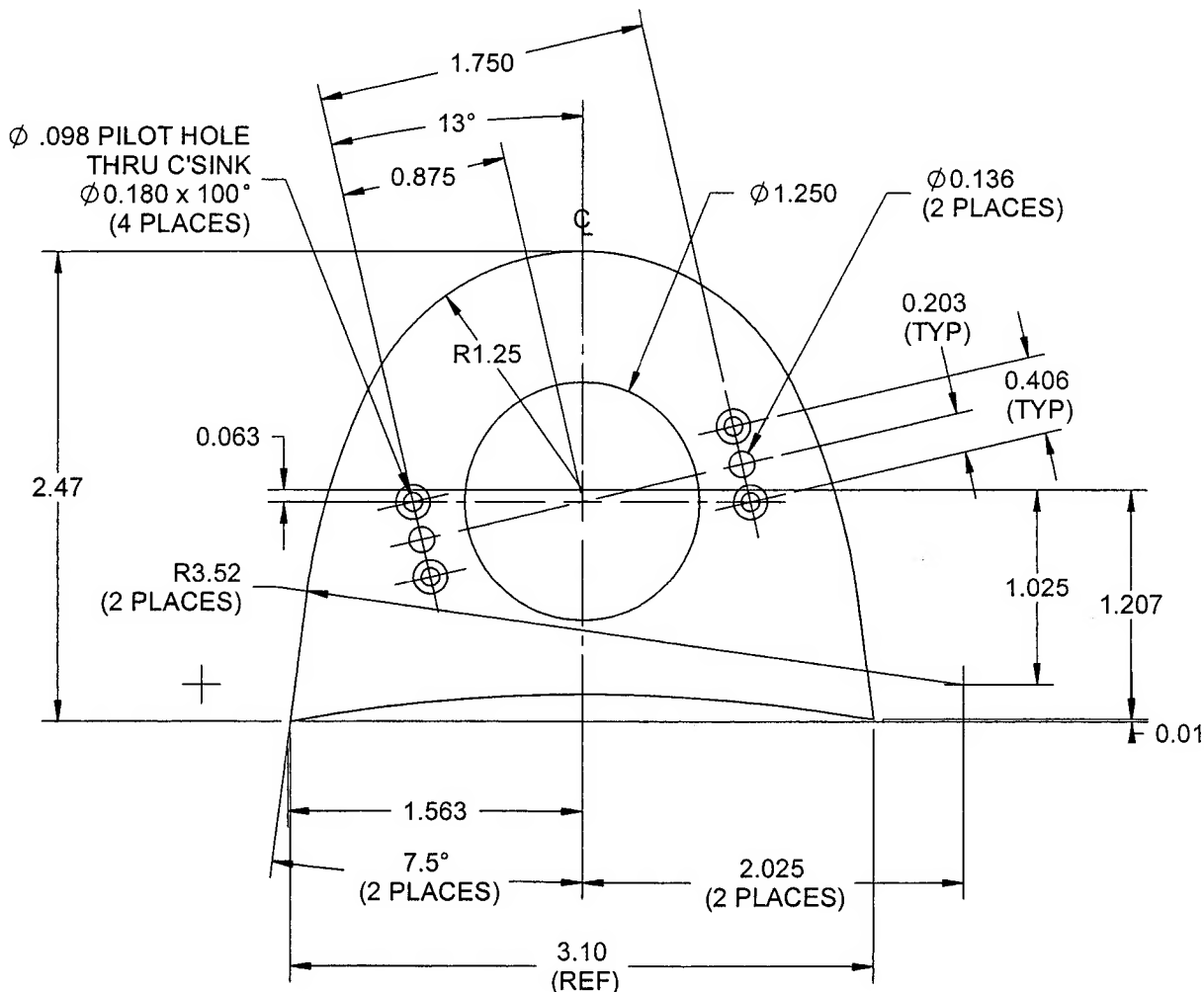
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DATE 06.04.20		TITLE TAIL LIGHT FAIRING	SCALE 1:1



**D3484-3 L/H FACE (-4 R/H, OPPOSITE)**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK) PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
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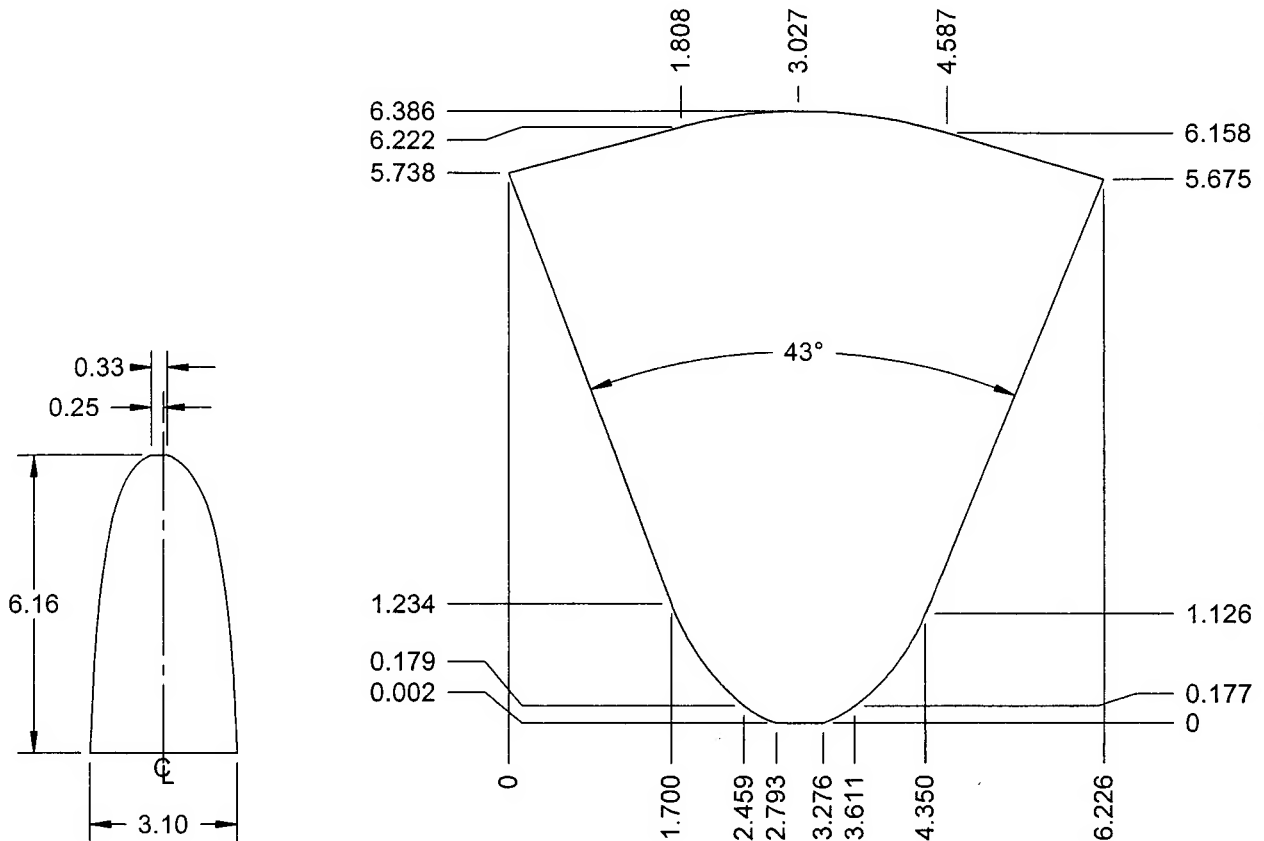
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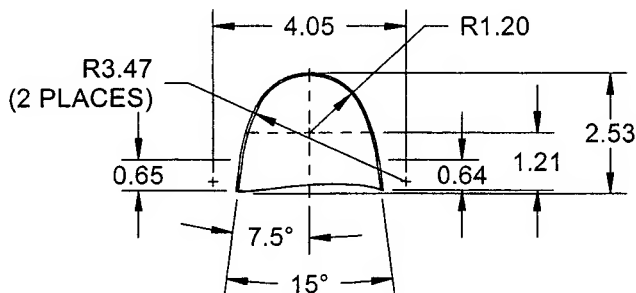
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06.05.16

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 06.04.20		TITLE TAIL LAMP FAIRING	SCALE 1:4



**D3484-5F CONE FLAT PATTERN**



**D3484-5 L/H CONE BENDING DETAIL (-6 R/H, OPPOSITE)**  
**(MAKE FROM D3484-5F)**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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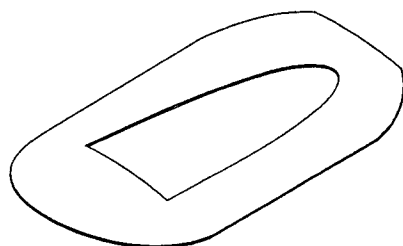
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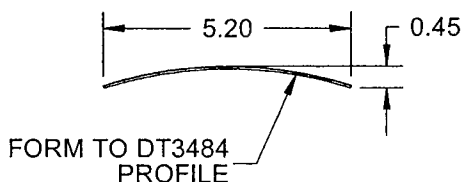


**PRELIMINARY ISSUE**  
06.05.16

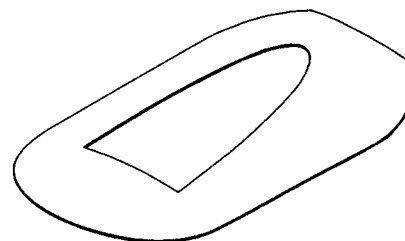
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CHECKED	APPROVED	DRAWING NO. <b>D3484</b>	REV. C SHEET 2 OF 4
DATE <b>06.04.20</b>		TITLE <b>TAIL LIGHT FAIRING</b>	SCALE 1:2



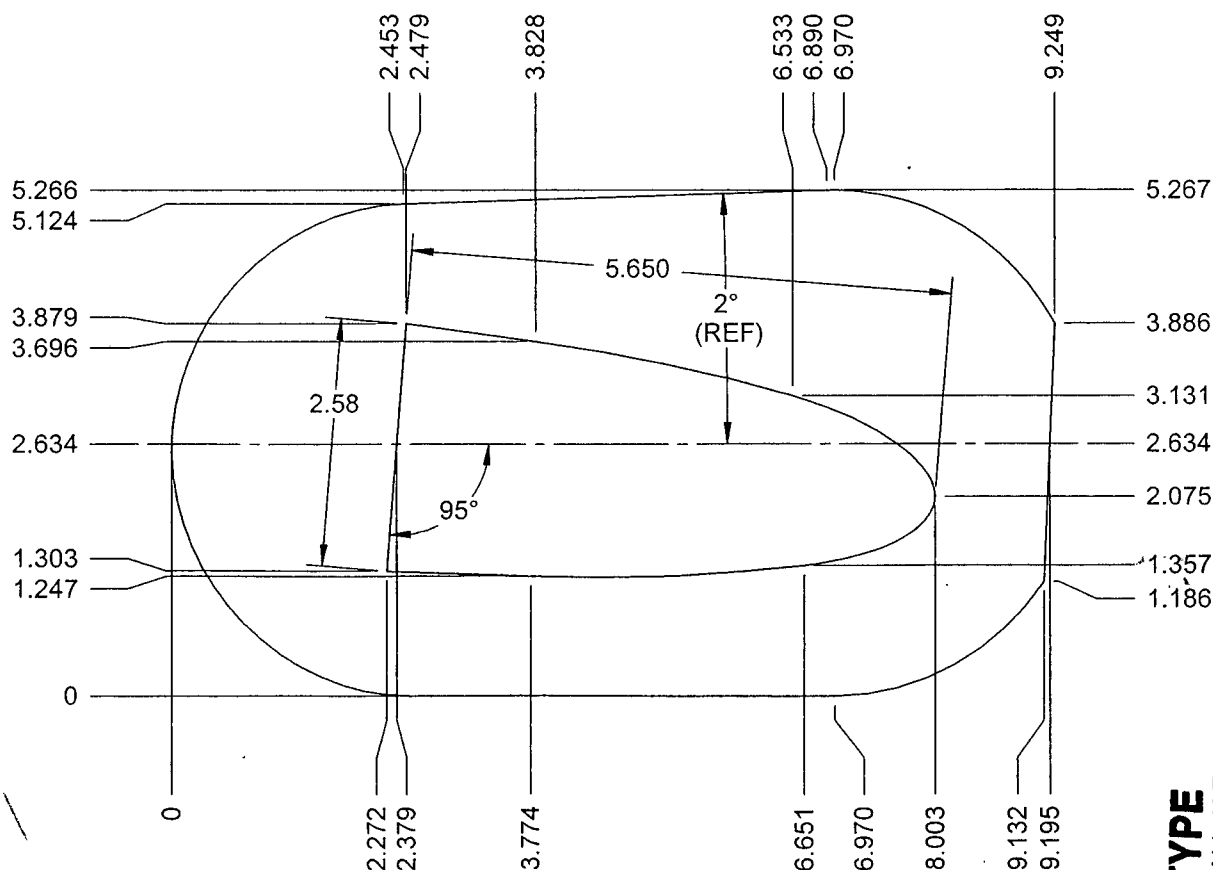
**D3484-1 BASE, L/H**



**D3484-1/-2 BENDING DETAIL**  
(MAKE FROM D3484-1F)



**D3484-2 BASE, R/H**



**D3484-1F BASE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
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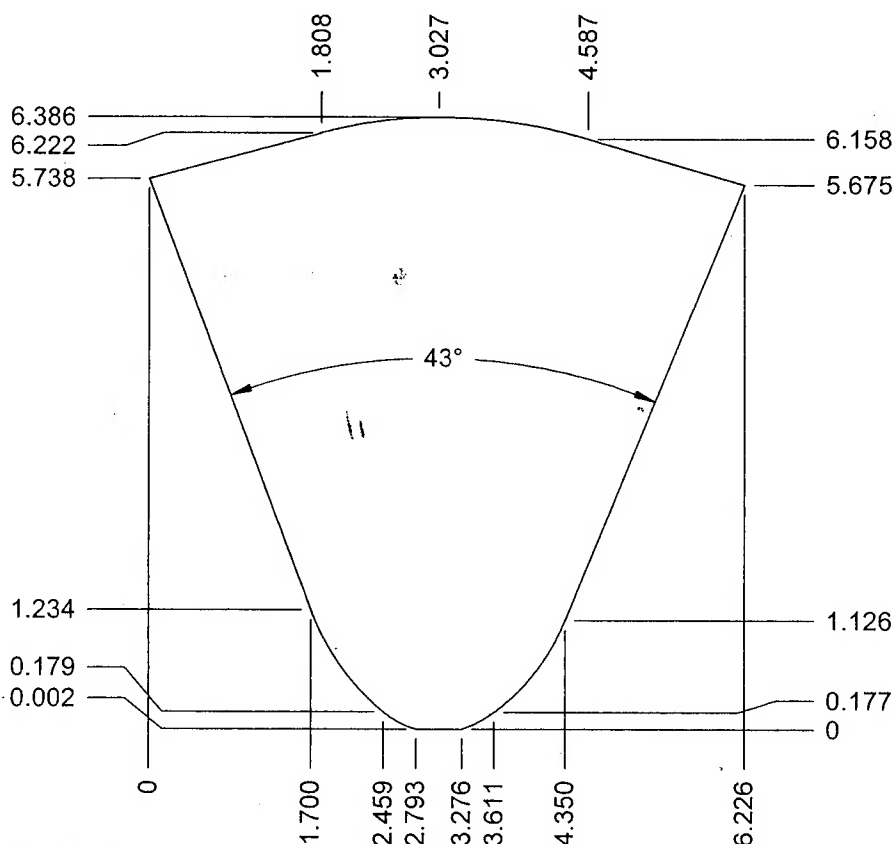
M17347

**PROTOTYPE**  
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06.05.16



06-05-16

06.04.20

**PROTOTYPE**  
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**NOTES:**

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DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

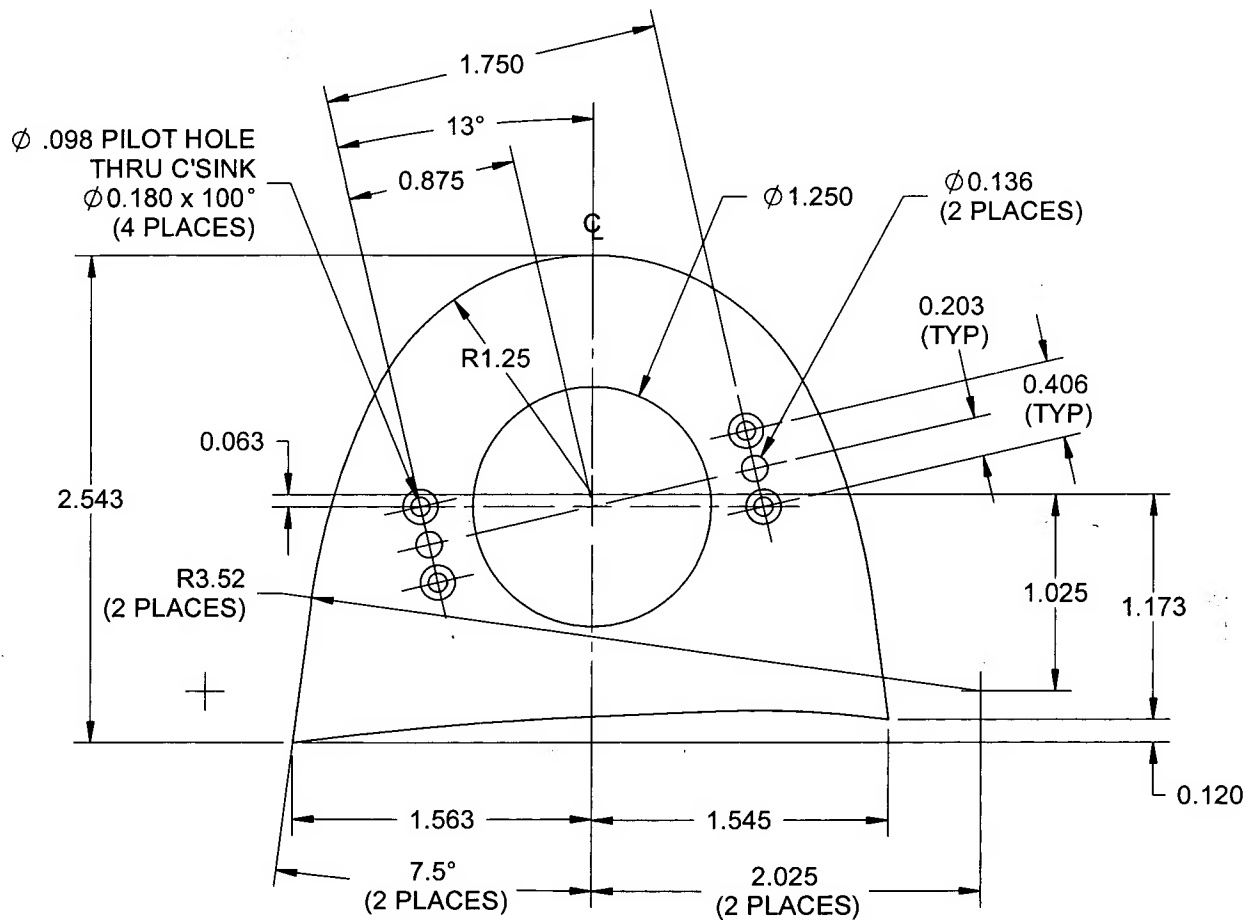
☒ First Article      ☒ Prototype

[illegible]

Measured by: <i>MM</i>	Audited by:	Prototype Approval:
Date: <i>06.05.17</i>	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DESIGN <i>13</i>	DRAWN BY <i>13</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3484</b>	REV. C SHEET 3 OF 4
DATE <b>06.04.20</b>		TITLE <b>TAIL LIGHT FAIRING</b>	SCALE 1:1



*M 17347*  
*6061 T6 0.050*

**D3484-3 L/H FACE (-4 R/H, OPPOSITE)**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
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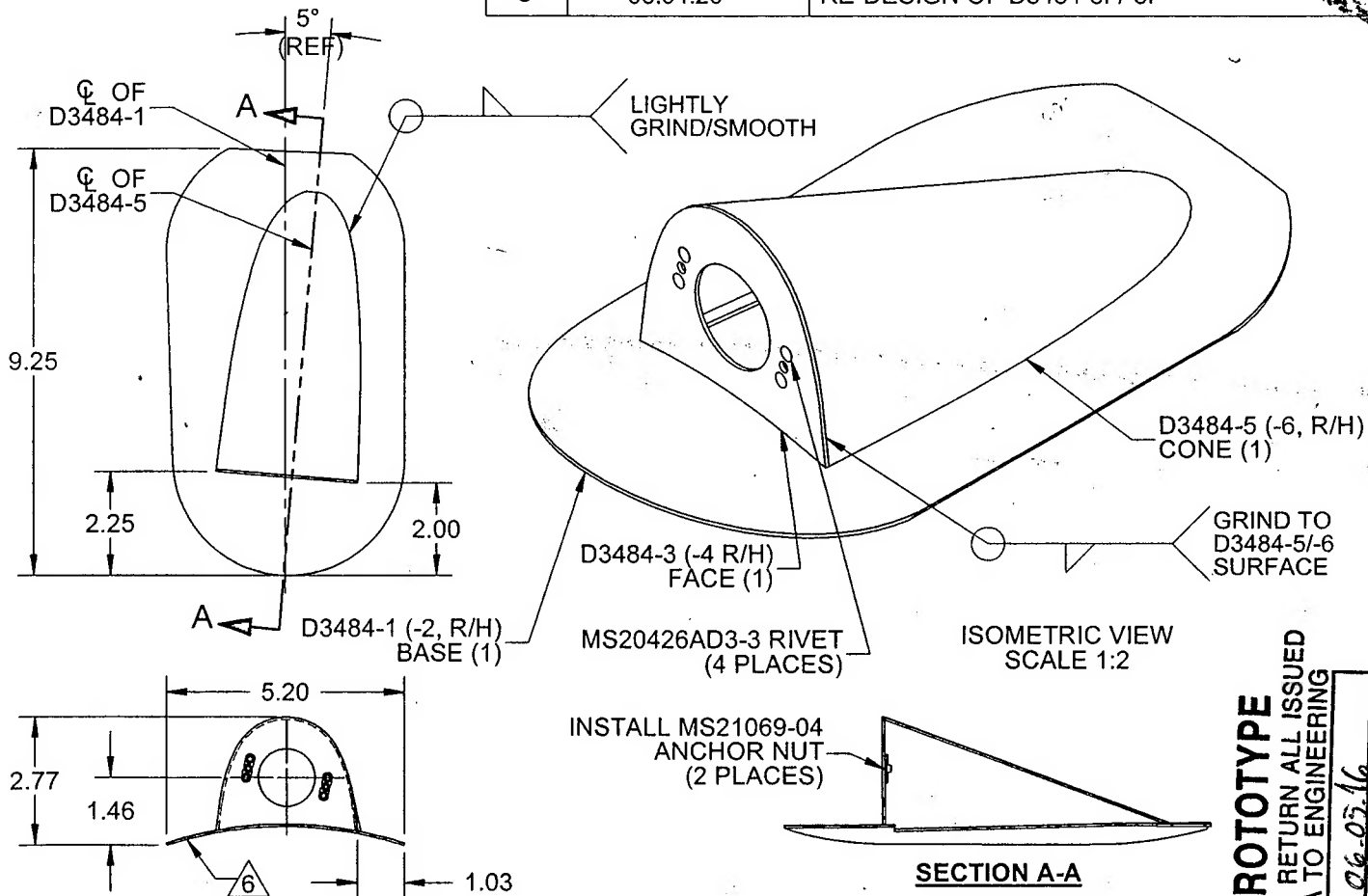
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CHECKED	APPROVED	DRAWING NO. <b>D3484</b>	REV. C SHEET 1 OF 4
DATE <b>06.04.20</b>		TITLE <b>TAIL LIGHT FAIRING</b>	SCALE 1:4
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	



**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POSSIBLE TO POWDER COAT PAINT WHITE (4.3.5.1) PER DART QSI 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD.,  
P/N D412-750-141/-142 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE  
PDA06-13"

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H)
1		D3484-3	FACE (L/H)
	1	D3484-4	FACE (R/H)
1		D3484-5	CONE (L/H)
	1	D3484-6	CONE (R/H)
4	4	MS20426AD3-3	RIVET
2	2	MS21069-04	ANCHOR NUT

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